

Date: Tuesday, 06/05/2008 3:52:47 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	HELI UTILITY BASKET
<b>Job Number</b> :	39083		
<b>Estimate Number</b> :	10854		
<b>P.O. Number</b> :		<b>Part Number</b> :	D350721041
<b>This Issue</b> :	06/05/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	N/A
<b>First Issue</b> :	06/05/2008	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	38824	<b>Drawing Revision</b> :	N/A
	<b>Type</b> :	<b>Material</b> :	
	LARGE FAB ASSY	<b>Due Date</b> :	30/05/2008
<b>Written By</b> :		<b>Qty:</b>	1 Um: Each
<b>Checked &amp; Approved By</b> :	<u>JLD 08.5.08</u>		
<b>Comment</b> :	Est Rev:D as per Rev B 05-11-21 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



JLD  
08.5.08



ECN 1205  
 ADDED  
 JLD

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D350-721-041CHG002

003 per ECN 1187

08.6.20

2.0	39083A	BASKET LID ASSEMBLY
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Comment: Sub-Component BASKET LID ASSEMBLY  
 D3325-041 B 39083A

EP 08/07/10 @

3.0	39083B	BASKET BASE ASSEMBLY
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Comment: Sub-Component BASKET BASE ASSEMBLY  
 D3324-041 B 39083B

EP 08/07/10 @

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Pick: Assembly Kit

5.0	D2022101	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
2 D2022-101	Spacer	<u>37521</u>

EP 8/7/10 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 3:52:47 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 39083

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2332041

Lid Prop Assembly 6.69" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2332-041

prop arm

38787

*[Signature]*

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch:

37853

*[Signature]*

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2535

Spring

37071

*[Signature]*

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2537

Bushing

39153

*[Signature]*

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2931

Bumper

21139

*[Signature]*

11.0

D3320041

Webbing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D3320-041

Webbing

B36177

*[Signature]* 8/7/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001: Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 39083

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D33511

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D3351-1

Label

34755

*Handwritten signature*

13.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt

M106815

*Handwritten signature*

14.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-7A

Bolt

M107321

*Handwritten signature*

15.0

AN420A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-20A

Bolt

M16895

*Handwritten signature*

16.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-22A

Bolt

M104937

*Handwritten signature*

17.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN5-17A

Bolt

M106815

*Handwritten signature*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

Date: Tuesday, 06/05/2008 3:52:47 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 39083

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD416

Washer M107739

*[Handwritten signature]*

19.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD416L

Washer M108138

*[Handwritten signature]*

20.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD516

Washer M107959

*[Handwritten signature]*

21.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD8

Washer M107650

*[Handwritten signature]*

22.0

AN960JD9

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

32 AN960JD9

Washer M105356

*[Handwritten signature]*

23.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN970-4

Washer M108077

*[Handwritten signature]*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 39083

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS20600AD4W3

Cherry Rivets



(P12) →

Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

32 MS20600AD4W3 Rivet 18671

4000 Rivet R# 106431

*Handwritten signature*

25.0

MS20600AD4W2

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS20600AD4W2 Rivet M106513

*Handwritten signature*

26.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M107665

*Handwritten signature*

27.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) M107478

*Handwritten signature*

28.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5) M107935

*Handwritten signature* 8/7/3 ①

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
8/7/9	24.	Perment change MS80600AD4WS Rints to MS80600AD4WS to compensate for new webbing B# 106431	B EB	08/07/09	ALL (732)	08.07.09 QSI 042	08/07/09

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Tuesday, 06/05/2008 3:52:47 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 39083

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg IIN-D350-721 Attach Travelers:

Seal rivet Holes with Sika Flex before riveting

A/R 291 Sika Flex

Batch:

Exp Date:

1107804

10/2008

EP 08/07/10 @

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/07/10 @

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

D22301

Lug



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

3 D2230-1

Lug

39315

R

33.0

D22303

Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2230-3

Clamp

39404

B

34.0

D2856400

Abrasion Strip



Comment: Qty.: 2.5200 f(s)/Unit Total : 2.5200 f(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2856-4007.20"

Abrasion Strip

36161

Le 07/3 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 39083

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D33381

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

1 D3338-1

Description

Lug

Batch

33248

36.0

D3350041

Strut Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

2 D3350-041

Description

Strut

Batch

136248

37.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

2 AN4-12A

Description

Bolt

Batch

1105143

38.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

8 AN4-13A

Description

Bolt

Batch

1107959

39.0

AN414A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

4 AN4-14A

Description

Bolt

Batch

1107534

8/7/3 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 3:52:47 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 39083

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

AN960JD416

Washer



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

Pick: Packing Kit

Qty Part Number

28 AN960JD416

Description

Washer

Batch

M107939

41.0

MS21042L4

Nut



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number

18 MS21042L4

Description

Nut (or -4)

Batch

M107478

42.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

43.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-721-041

Location:

PPP Rev:

44.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MK 08-0710

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## 5.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-721-041 Lightweight Heli-Utility-basket™, LH or RH	35 lb 15.9 kg	± 44.1 in ± 1.12 m	± 1543.5 lb-in ± 17.8 kg-m	135 in 3.43 m	4725 lb-in 54.5 kg-m
D350-721-041 Lightweight Heli-Utility-basket™, Dual basket installation	70 lb 31.8 kg	0 in 0 m	0 lb-in 0 kg-m	135 in 3.43 m	9450 lb-in 109.1 kg-m
D350-721-043 Lightweight Heli-Utility-basket™, Short Version, LH or RH	25 lb 11.3 kg	± 44.1 in ± 1.12 m	± 1102.5 lb-in ± 12.7 kg-m	135 in 3.43 m	3375 lb-in 38.8 kg-m
D350-721-043 Lightweight Heli-Utility-basket™, Short Version, Dual basket installation	50 lb 22.7 kg	0 in 0 m	0 lb-in 0 kg-m	135 in 3.43 m	6750 lb-in 77.8 kg-m
D350-721-041/-043 Lightweight Heli-Utility-Basket™, Clamps Only, LH or RH	0.7 lb 0.3 kg	± 36.6 in ± 0.9 in	± 25.6 lb-in ± 0.3 kg-m	135 in 3.43 m	94.5 lb-in 1.0 kg-m
D350-721-041/-043 Lightweight Heli-Utility-Basket™, Clamps Only, Dual basket installation	1.3 lb 0.6 kg	0 in 0 m	0 lb-in 0 lb-in	135 in 3.43 m	175.5 lb-in 2.0 kg-m

## 6.0 PARTS LIST

Qty -041	Qty -043	Part Number	Description
X		D350-721-041	LIGHTWEIGHT HELI-UTILITY-BASKET™
	X	D350-721-043	LIGHTWEIGHT HELI-UTILITY-BASKET™, SHORT VERSION
1		D3324-041	BASKET BASE ASSEMBLY
1		D3325-041	BASKET LID ASSEMBLY
	1	D3326-041	BASKET BASE ASSEMBLY
	1	D3327-041	BASKET LID ASSEMBLY
2	2	D2022-101	SPACER
3	3	D2230-1	LUG
4	4	D2230-3	CLAMP
1	1	D2332-041	PROP ASSEMBLY
1	1	D2530	HANDLE ASSEMBLY
2	2	D2535	SPRING
2	2	D2537	BUSHING
4	4	D2856-400-720	ABRASION STRIP
2	2	D2931	BUMPER
1	1	D3338-1	LUG
2	2	D3350-041	STRUT
1	1	D3351-1	LABEL
2	2	AN3-16A	BOLT
2	2	AN4-7A	BOLT
2	2	AN4-12A	BOLT
8	8	AN4-13A	BOLT
4	4	AN4-14A	BOLT
1	1	AN4-20A	BOLT
1	1	AN4-22A	BOLT
4	4	AN5-17A	BOLT
30	30	AN960JD416	WASHER
2	2	AN960JD416L	WASHER
4	4	AN960JD516	WASHER
2	2	AN960JD8	WASHER
4	4	AN970-4	WASHER
2	2	MS20600AD4W3	RIVET
2	2	MS21042L3	NUT (OR MS21042-3)
18	18	MS21042L4	NUT (OR MS21042-4)
4	4	MS21042L5	NUT (OR MS21042-5)

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO 39083

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Revision: A

Date: 04.11.18

Date: Tuesday, 06/05/2008 4:24:14 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BASKET LID ASSEMBLY
<b>Job Number</b> :	39083A		
<b>Estimate Number</b> :	10853		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3325041
<b>This Issue</b> :	06/05/2008	<b>Drawing Number</b> :	D3325 REV B
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	/ /	<b>Drawing Revision</b> :	B
<b>Previous Run</b> :	38824A	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	30/05/2008
<b>Checked &amp; Approved By</b> :	<u>JLD 08.5.06</u>	<b>Qty:</b>	1 Um: Each
<b>Comment</b> :	Est Rev:A 05.02.09 New issue KJ/JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D33281	Basket Hinge
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 D3328-1	Hinge Plate	<u>B34123</u>

PD 08-06-26

2.0	D33491	Spacer Bushing
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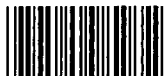
**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 D3349-1	Spacer Bushing	<u>B34205</u>

PD 08-06-26

3.0	D33521	Label Plate
-----	--------	-------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 D3352-1	Label Plate	<u>B34206</u>

PD 08-06-26

4.0	D33671	Mounting Bracket
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 D3367-1	Mounting Bracket	<u>B38179</u>

PD 08-06-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 06/05/2008 4:24:14 PM  
User: Julie-Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 39083A

Part Number: D3325041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

M4130NTS0500W035

4130 Square tube .5 x .5



Comment: Qty.: 21.5687 f(s)/Unit Total: 21.5687 f(s)  
Material: 4130 Cond. N Square tube per MIL-T-6736,  
1/2" x 0.035" wall  
M4130N-TS0.500W.035)

SAD 08/06/24 (1)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FAB 1

Qty Part Number Description Batch  
2 D3325-1 EndTube M108058  
3 D3325-3 Interior Tube M108058  
2 D3325-5 Full Lengh Tube M108031 (1) M108058 (1)

SAD 08/06/24 (1)

Identify parts appropriately

2-Remove all markings from material

3-Drill and Weld as per Dwg D3325 & QSI 004  
A/R4130 Steel Rod M102226

PD 08-06-26

4-Deburr as required

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10/07/07

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/08/07 (1)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 11:30 AM  
OVEN TEMPERATURE: 4000 F  
FINISH TIME: 12:00 PM

08-07-08

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 4:24:14 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 39083A

Part Number: D3325041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Py 08/07/08 @*

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *GA*

*08/07/10 @*

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/07/10*

Job Completion



*MF 08-07-10*

**Dart Aerospace Ltd**

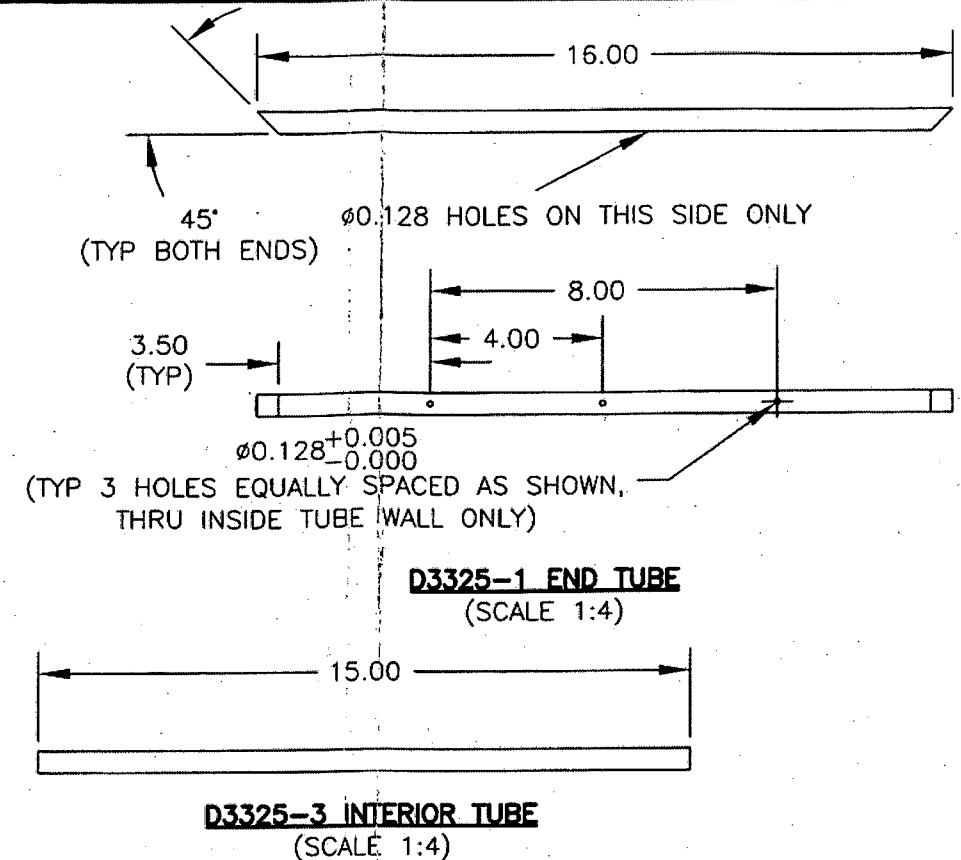
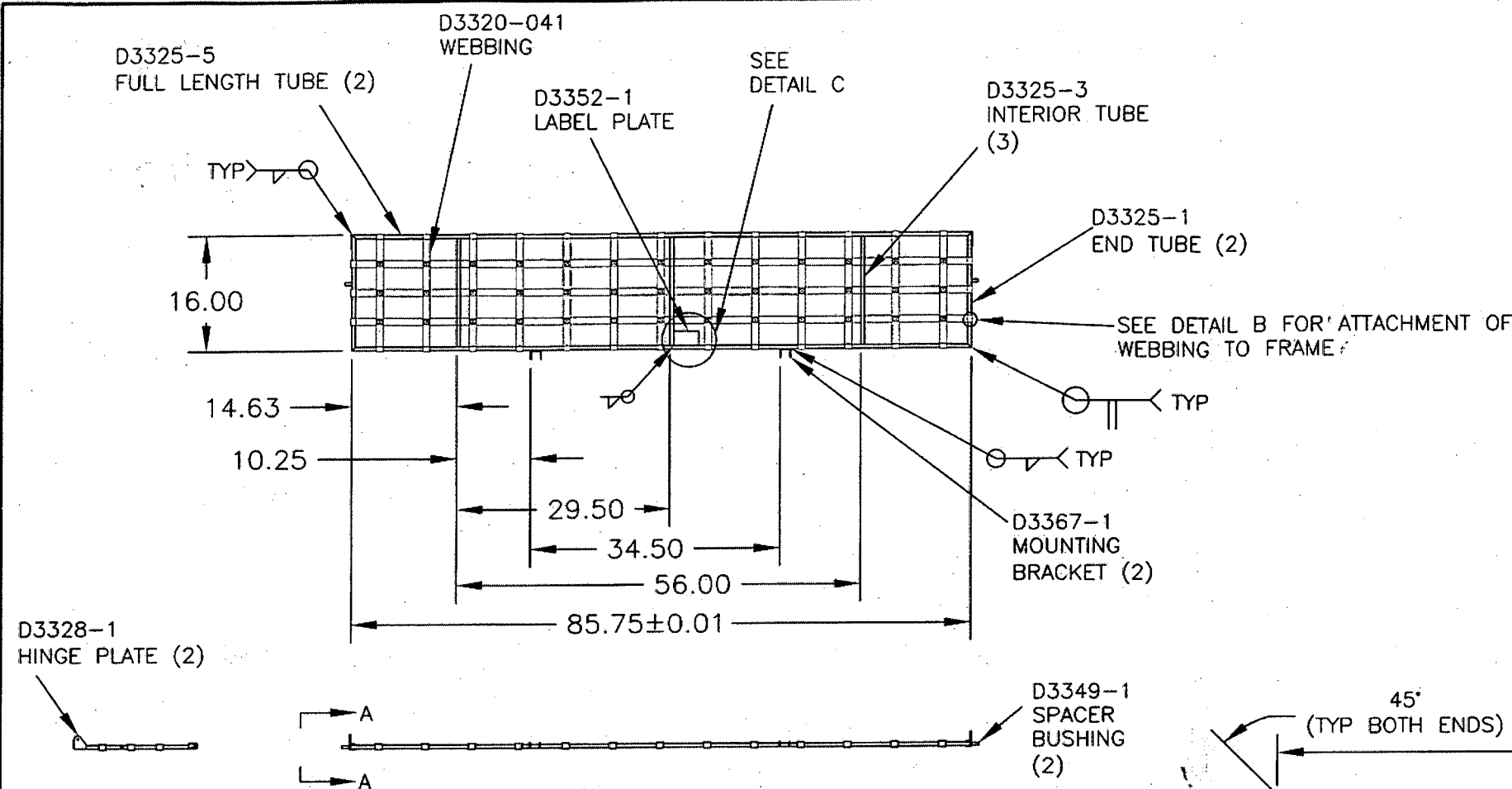
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



#### D3325-041 BASKET LID ASSEMBLY

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 (PRIOR TO INSTALLATION OF D3320-041)
- 2) WELD PER DART QSI 004
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

#### PARTS LIST FOR D3325-041 BASKET LID ASSEMBLY

Part No.	Quantity	Description
D2729-1	1	PRODUCT ID LABEL
D3320-041	1	WEBBING
D3325-1	2	END TUBE
D3325-3	3	INTERIOR TUBE
D3325-5	2	FULL LENGTH TUBE
D3328-1	2	HINGE PLATE
D3349-1	2	SPACER BUSHING
D3351-1	1	PLACARD
D3352-1	1	LABEL PLATE
D3367-1	2	MOUNTING BRACKET
MS20600AD4W3	32	RIVET
AN960JD9	32	WASHER

RELEASED  
05-04-28

0.128<sup>+0.005</sup><sub>-0.000</sub>  
(TYP 13 HOLES, EQUALLY SPACED,  
THRU INSIDE TUBE WALL ONLY)

#### D3325-1/-3/-5

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE, AMS-T-6736, 1/2" X 0.035 (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

#### D3325-5 FULL LENGTH TUBE (NOT TO SCALE)

B	05.04.25	CHANGE RIVET AND HOLE DIAMETER
A	04.10.21	NEW ISSUE
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED JH	APPROVED JH	DRAWING NO. D3325
DATE 05.04.25	TITLE BASKET LID ASSEMBLY	REV. B SHEET 1 OF 3 SCALE 1:20

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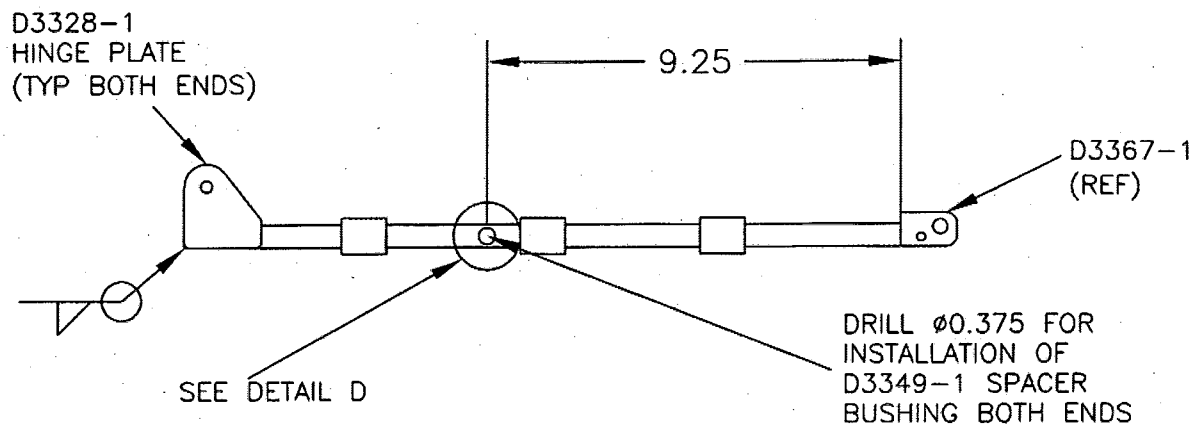
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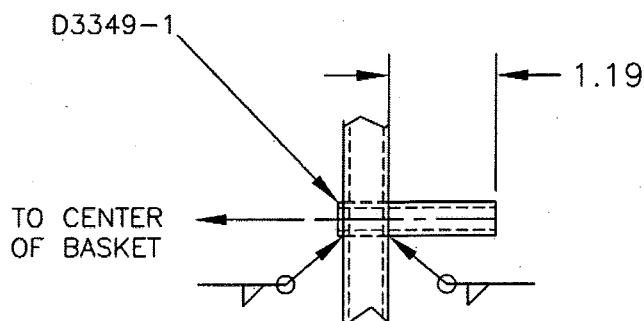




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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4



VIEW A-A



DETAIL D  
(SCALE 1:2)

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05.04.28 [Signature]

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NO. 39083A

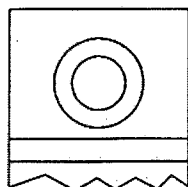
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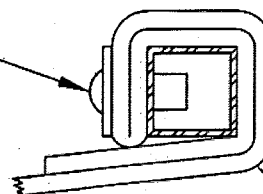


DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3325	REV. B SHEET 3 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

MS20600AD4W3 RIVET (1)  
AN960JD9 WASHER (1)



DETAIL B  
TYP. ATTACHMENT OF WEBBING TO LID  
FRAME  
(SCALE 1:1)

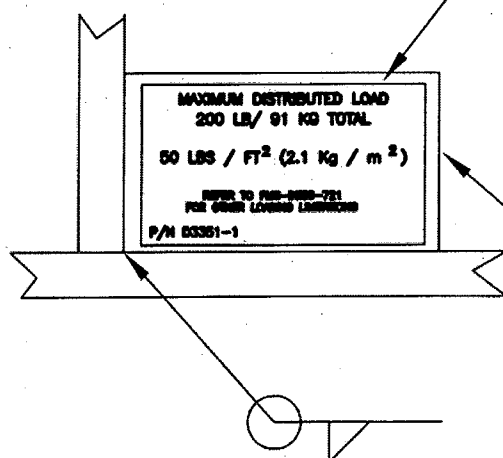


D3320-041 WEBBING

**RELEASED**  
05.04.28

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WORK ORDER  
NO. 3908317

ATTACH D3351-1 PLACARD  
ON TOPSIDE OF D3352-1



D3352-1

IDENTIFY WITH DART P/N  
D350-721-041 USING  
D2729-1 PRODUCT ID LABEL  
INSTALLED ON UNDERSIDE OF  
D3352-1

DETAIL C  
LABEL PLATE ATTACHMENT  
(SCALE 1:2)

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Date: Tuesday, 06/05/2008 4:24:33 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASSEMBLY
Job Number	: 39083B		
Estimate Number	: 10852		
P.O. Number	:	Part Number	: D3324041
This Issue	: 06/05/2008 S.O. No. :	Drawing Number	: D3324 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 38824B	Material	:
Written By	:	Due Date	: 30/05/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JLD 08-5-06</u>		
Comment	: Est Rev:A 05.02.09 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D33283	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3328-3 Hinge Plate

B34124

PD 08-06-26

2.0	D33481	Clevis
-----	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3348-1 Clevis

B37583

PD 08-06-26

3.0	D33493	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3349-3 Spacer Bushing

B38178

PD 08-06-26

4.0	D33671	Mounting Bracket
-----	--------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3367-1 Mounting Bracket

B38179

PD 08-06-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 06/05/2008 4:24:33 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 39083B

Part Number: D3324041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M4130NTS0500W035

4130 Square tube .5 x .5



✓  
Comment: Qty.: 48.9300 f(s)/Unit Total : 48.9300 f(s)  
Material: 4130 Cond. N Square tube per MIL-T-6736,  
1/2" x 0.035" wall  
M4130N-TS0.500W.035)

SAD

08/06/24

①

6.0

M569EX05018F

569 Expanded Metal



Comment: Qty.: 28.0000 sf(s)/Unit Total : 28.0000 sf(s)

Pick:

Qty Part Number Description

Batch

28s M569EX0.50-18F 1/2"-18gauge(.040") carbon steel

M107677

08/07/07

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut tubes as per Dwg D3324

Qty Part Number Description

Batch

3 D3324-1 Bottom Tube M108058

4 D3324-3 Full Length Tube M108058

2 D3324-5 Top End Tube M108058

2 D3324-7 Bottom End Tube M108058

10 D3324-9 Vertical Tube M108058

Identify parts appropriately

SAD 08/06/24

①

2-Remove all markings from material & check for foreign objects

3-Drill and Weld as per Dwg D3324 & QSI 004 using DT8781 A & B

A/R4130 Steel Rod H100 M102226

DD 08-06-26

08/07/02

4-Deburr as required

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/07/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 4:24:33 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 39083B

Part Number: D3324041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/07/07*

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

*11:30 AM*

OVEN TEMPERATURE:

*400°C*

FINISH TIME:

*12:00 PM*

*ell*

*08-07-08*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FL 08/37/08*

*(1)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*G.A*

*EP 08/07/10*

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/07/10*

Job Completion



*mf 08-07-10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

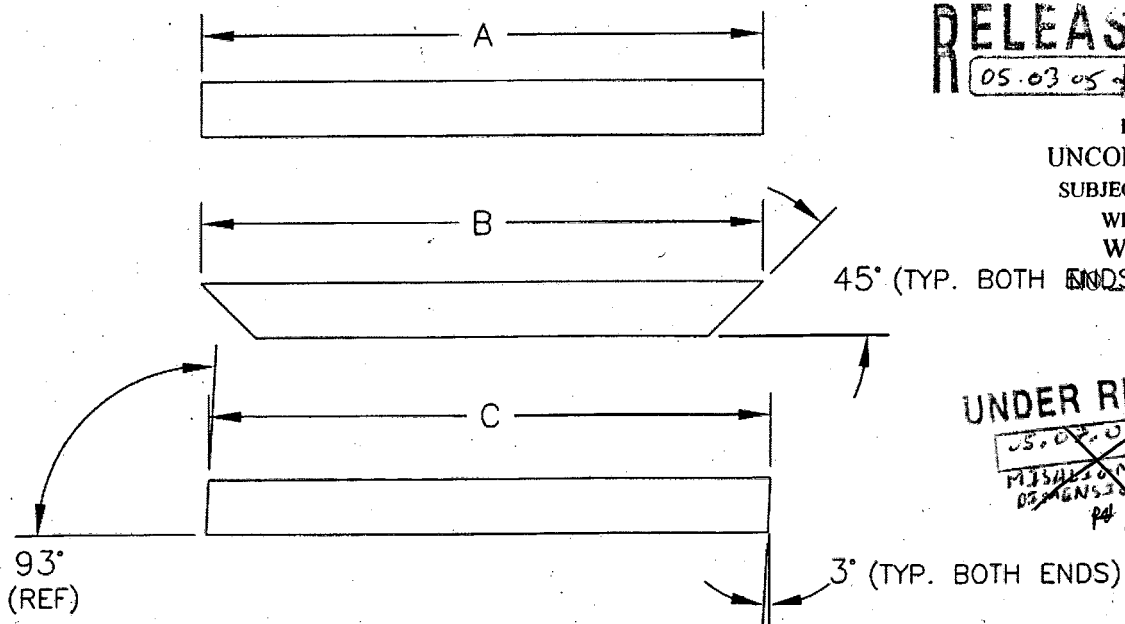


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DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.20	NEW ISSUE	
B	05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



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05.03.05

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WORK ORDER  
390230

**UNDER REVIEW**  
05.03.07 PH  
MISSED  
DIMENSION PG 2  
PH 06.05.07

D3324-1/-3/-5/-7/-9

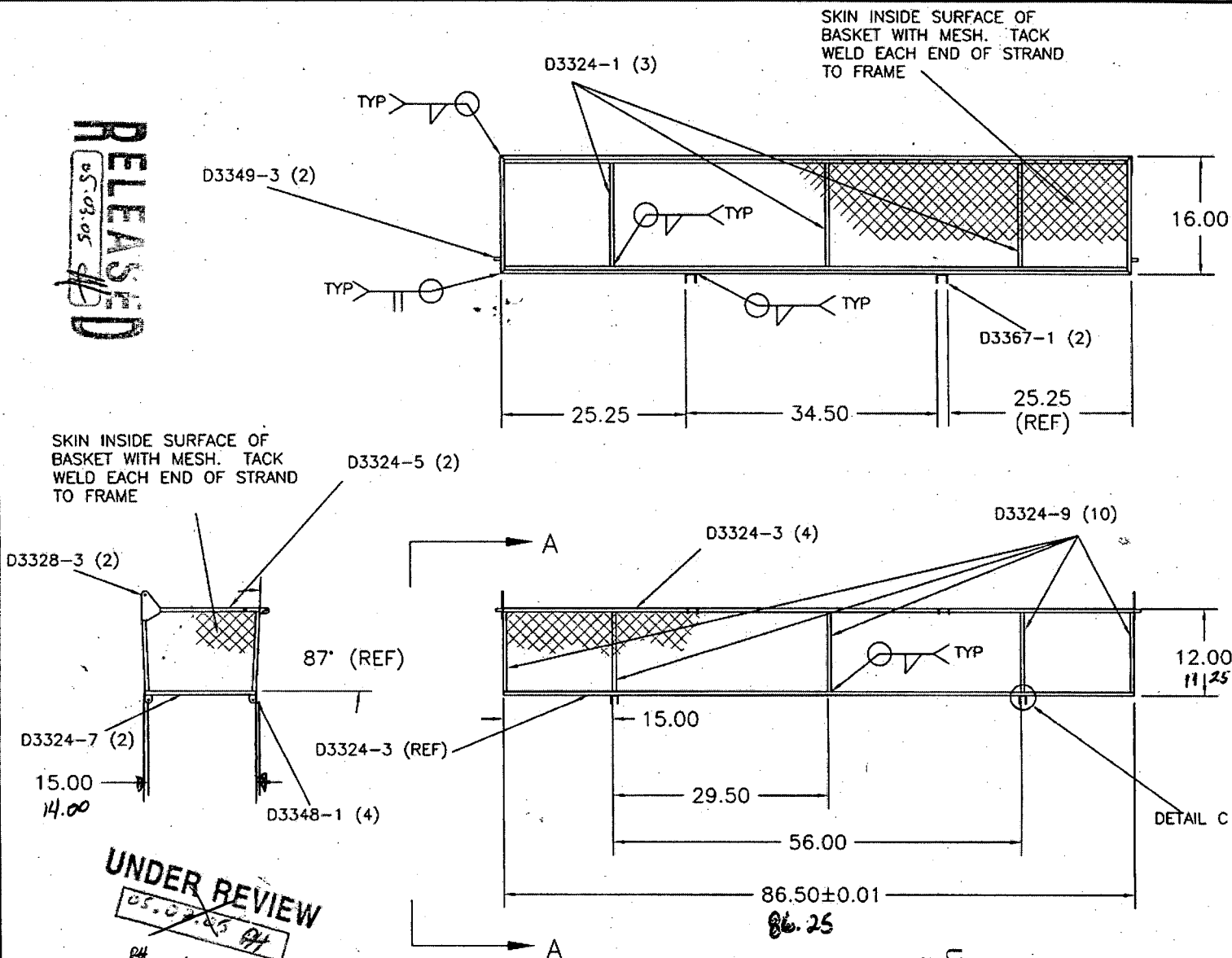
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL  
(REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	TITLE	DRAWING NO.	SHEET 2 OF 3
05.03.04	BASKET BASE ASSEMBLY	D3324	SCALE
			1:20



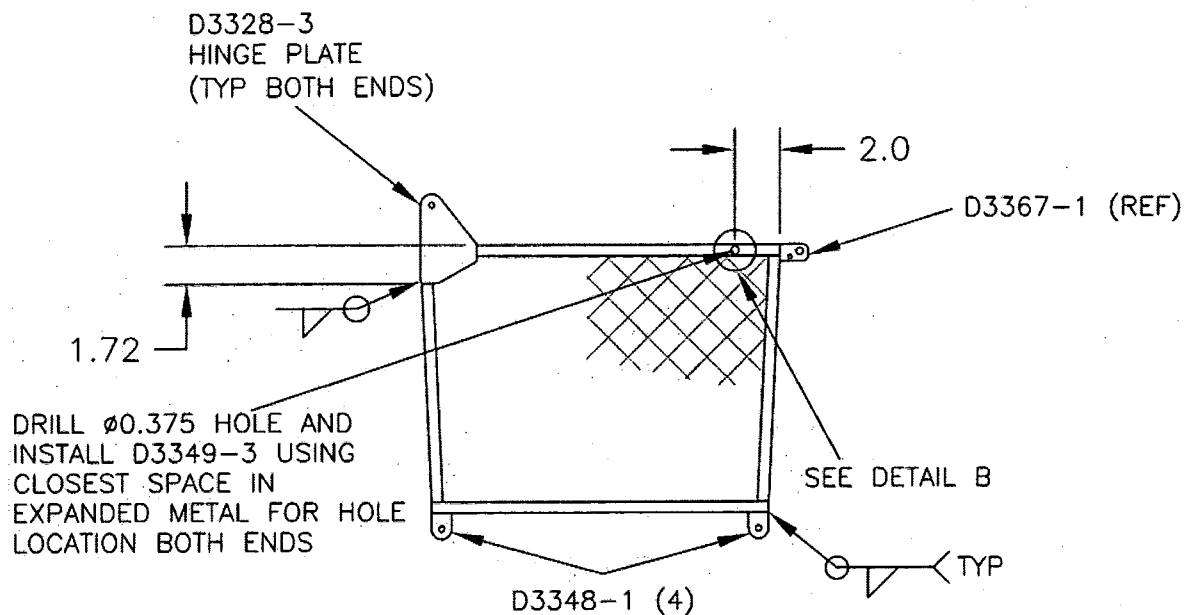
**D3324-041 BASKET BASE ASSEMBLY**

- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

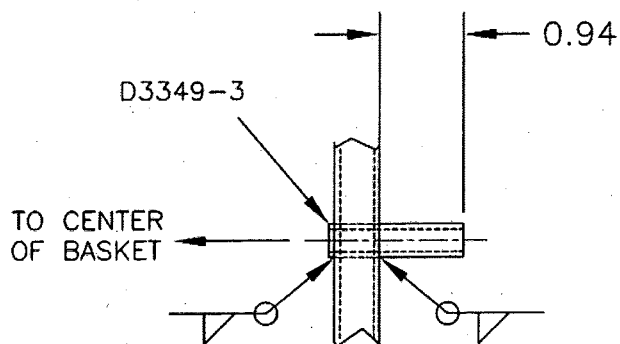
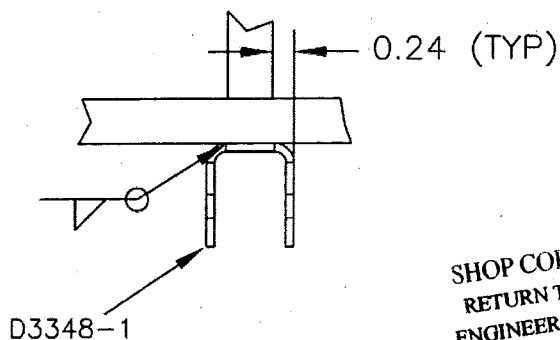
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3324	REV. B SHEET 3 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8



VIEW A-A

**RELEASED**  
05-03-05DETAIL B  
(SCALE 1:2)DETAIL C  
(SCALE 1:2)**UNDER REVIEW**  
05-07-06 PH  
06-05-07 PH

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